

Date: Monday, 2/5/2007 4:03:11 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WASHER
Job Number : 30662	
Estimate Number : 12298	
P.O. Number : N/A	Part Number : D34931
This Issue : 2/5/2007 S.O. No. : N/A	Drawing Number : D3493 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 2/5/2007 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 29798	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 2/23/2007 Qty: 30 Um: Each
Checked & Approved By : <u>[Signature]</u> 07.02.06	
Comment : Est Rev: A New Issue 06-02-28 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R1000	Inventory
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Comment: Qty.: 0.0306 f(s)/Unit Total : 0.9167 f(s)  
 1.00" 304 ROUND BAR  
 (M304R1.000)  
 Batch: M17002

DIP 07/04/14

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA626 &amp; Dwg D3493

2-Deburr

DIP 07/04/14 / A.F 07/04/17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QMR / J.B 07/04/17

TURN  
→  
OVER

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/04/19 (41)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock  
 Location: \_\_\_\_\_

07/04/19 (41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.04.19	3	INSIDE DIAMETER IS <del>φ0.570</del> nominal is φ0.516	RH PER 07.04.19 QSS 042	ACCEPTABLE DEVIATION  SEE ATTACHED E-MAIL	RH 07.04.19	07/04/19		

NOTE: Date & initial all entries

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Drawing Name: WASHER

Job Number: 30662

Part Number: D34931

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(41)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/04/00

Job Completion



u 8704-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

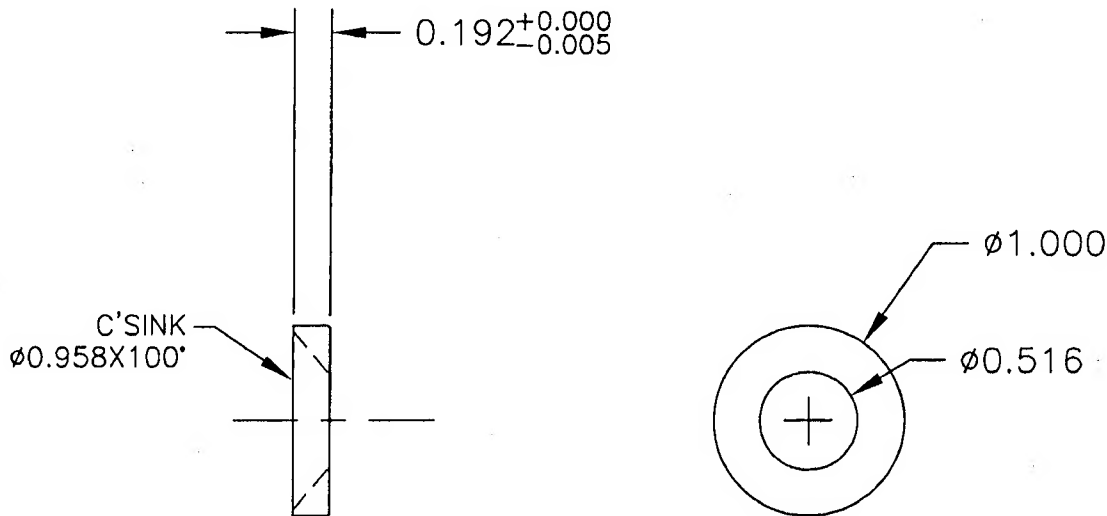
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3493	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE WASHER	SCALE 1:1
A	06.01.04	NEW ISSUE	



D3493-1 WASHER

D3493-1 WASHER

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL  $\phi 1.000$  ROUND BAR  
(REF DART MATERIAL SPEC M304R1.000)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY  
RECEIVED  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30662

**RELEASED**  
06.02.07 H

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**Peter Hum**

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**From:** Peter Hum [phum@dartaero.com]  
**Sent:** April 18, 2007 12:00 PM  
**To:** 'David Shepherd'  
**Cc:** 'Jason Murdoch'  
**Subject:** D3493-1 washer  
**Attachments:** 350apicalbolt 001.jpg; D3493-1A-big ID.pdf

David,

Production is making a batch of D3493-1 washers and the inside hole dimension is 0.570 OD (0.516 is the nominal). These washers are used when the customer is installing an Apical float system using the long countersunk bolt provided by Apical. The purpose of this washer is to convert the countersunk head of the Apical bolt to a flat head in order to fit the Dart D2741 blade.

This deviation was caused by over deburring

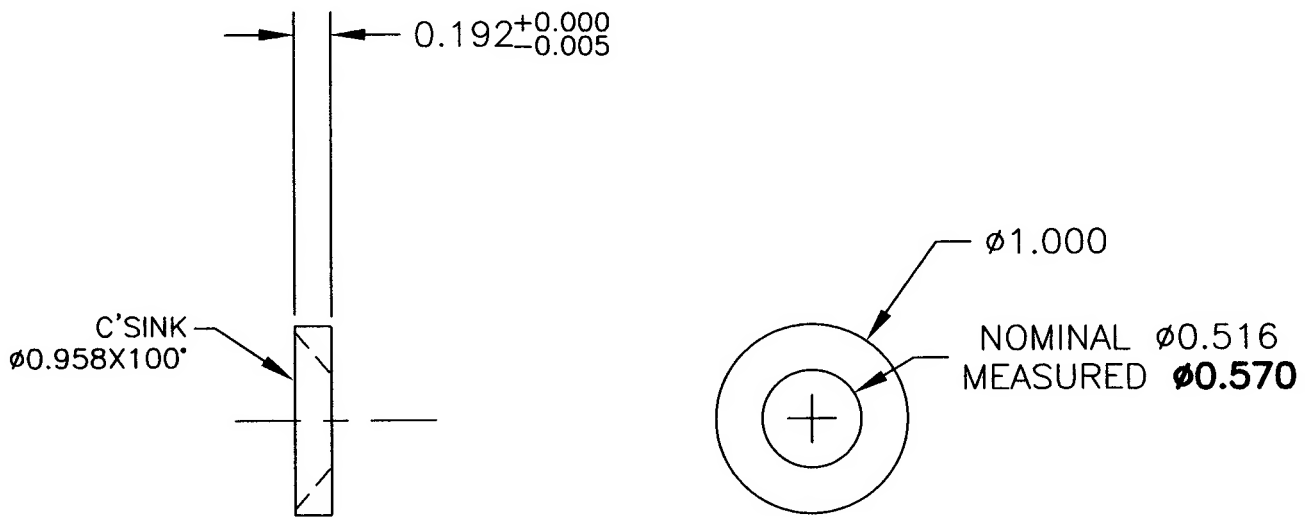
I've attached pictures showing this washer with the Apical bolt. This deviation does not affect the form or intended function of the washer.

Is this deviation acceptable?

Peter

19/04/2007

DESIGN	DRAWN BY	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3493	REV. A SHEET 1 OF 1
DATE 06.01.04	TITLE WASHER		SCALE 1:1
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D3493-1 WASHER

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